

## Work Order ID 51944



Page 1

Thursday, September 10, 2009 8:24:55 AM

Item ID: D3065-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: 09-9-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3065    | Rev B        |

100



Waterjet

FLOW WATER JET

FLOW CNC Waterjet

*2024 .040*

Memo

0.00

*R 9-9-15*1-Cut as per Dwg D  Dwg Rev: *B*  Prog Rev: *B*  2-Deburr  
if necessary*(44)*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*R 9-9-15*

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

*→ Solaris**Counted  
(X44)*

Memo

0.00

*✓*

**Work Order ID 51944**

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Start Date: 9/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Draw  
Number**
**Draw  
Rev.**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

130



Small Fab

0.00

N/A<sub>5</sub>

Small Fab

Memo

0.00

Small Fab

Deburr Stack

140



NC BRAKE

0.00

SB 09/09/17

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

150



QC5- Inspect part completeness to step on W/O

0.00

Counted  
+44

=&gt; Sat 02/17

QC

Memo

0.00

Quality Control

**Work Order ID 51944**

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Thursday, September 10, 2009 8:24:55 AM

Item ID: D3065-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/09/21



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

M.L 09/09/21



QC

Quality Control

Memo

0.00

180

Identify as per dwg &amp; Stock Location: Sylvie 0.00

0.00



Packaging

Memo

Packaging



# Picklist Print

Page 1

Thursday, September 10, 2009 8:25:02 AM

Work Order ID: 51944



Parent Item: D3065-3RevB



Parent Item Name: Step Spacer

Start Date: 9/11/2009

Required Date: 9/25/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status    |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|-----------|
| M2024T3S.040                    |                        | Purchased     |             | No                  |                  | 100             | sf                 | 230.3565       | 9.1705                   | 10.0925       |                | IR 9-9-15 |

2024-T3 .040 sheet

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

|        |             |  |
|--------|-------------|--|
| MAT    | 230.3564789 |  |
| 110337 | 6.4         |  |
| 111786 | 39.0665789  |  |
| 112291 | 91.9258     |  |
| 112331 | 92.9641     |  |

112331 X 44

|                          |              |             |
|--------------------------|--------------|-------------|
| DART AEROSPACE LTD       | Work Order:  | 57544       |
| Description: Step Spacer | Part Number: | D3065-3     |
| Inspection Dwg: D3065    | Rev: B       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

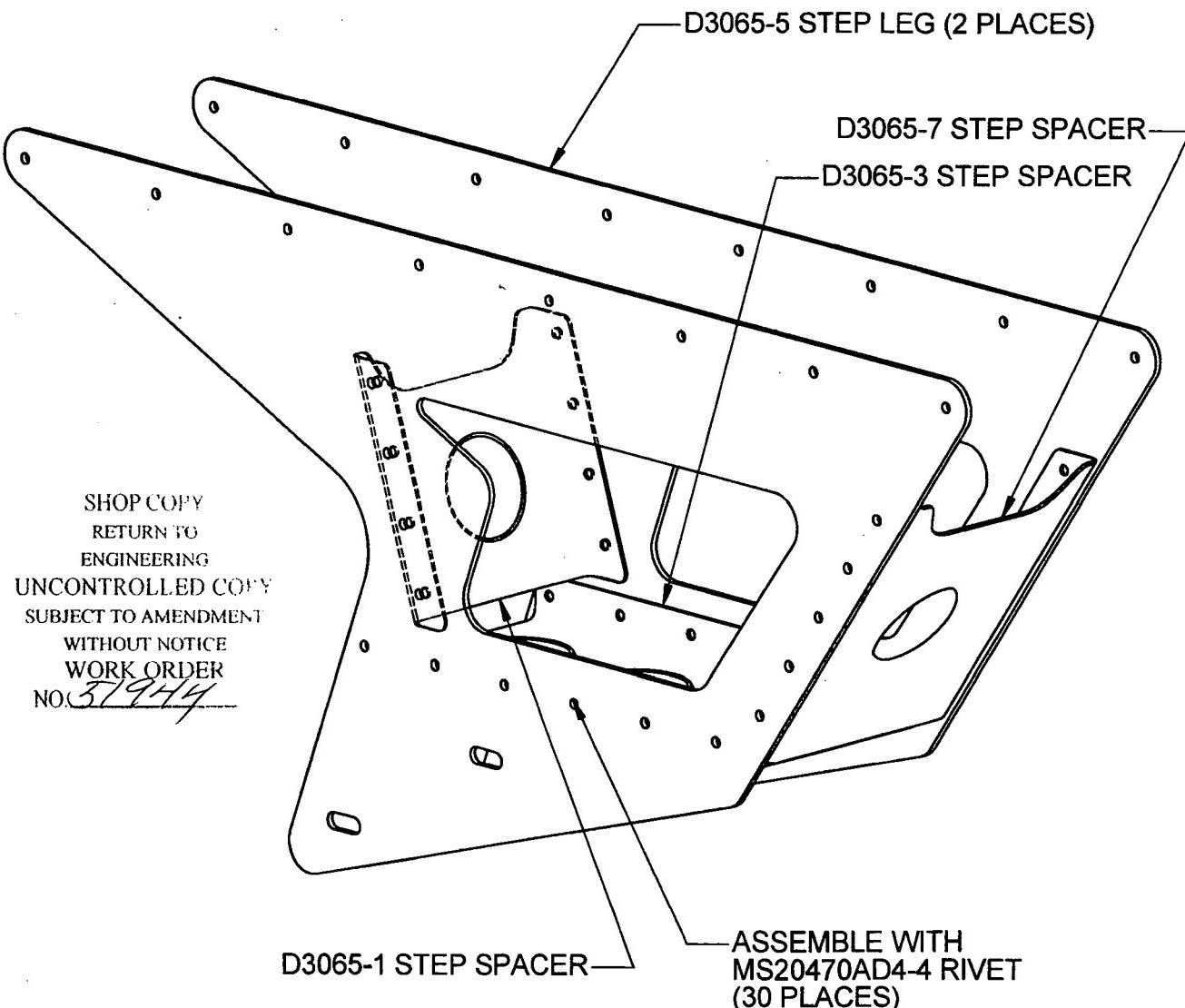
## X First Article      Prototype

|              |           |             |          |                     |     |
|--------------|-----------|-------------|----------|---------------------|-----|
| Measured by: | <u>AB</u> | Audited by: | <u>S</u> | Prototype Approval: | N/A |
| Date:        | 9-9-15    | Date:       | 07/06/15 | Date:               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b>           | <b>Revised by</b> | <b>Approved</b> |
|------------|-------------|-------------------------|-------------------|-----------------|
| A          | 04.02.25    | New Issue P/O D3065-041 | KJ/RF             |                 |
| B          | 04.08.12    | Removed dimension 1.204 | KJ/JLM            |                 |
| C          | 06.06.23    | Dwg Rev. changed        | KJ/JLM            |                 |
| D          | 07.09.06    | 0.040 dimension added   | KJ/JLM            | Z               |

**DART**

|                      |                                |  |
|----------------------|--------------------------------|--|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3065                                     |
| DATE<br>06.05.23     |                                | REV. B<br>SHEET 1 OF 5                                   |
|                      |                                | TITLE<br><b>STEP LEG ASSEMBLY</b>                        |
|                      |                                | SCALE<br>1:2   |
| A                    | 02.09.11                       | NEW ISSUE  |
| B                    | 06.05.23                       | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5               |

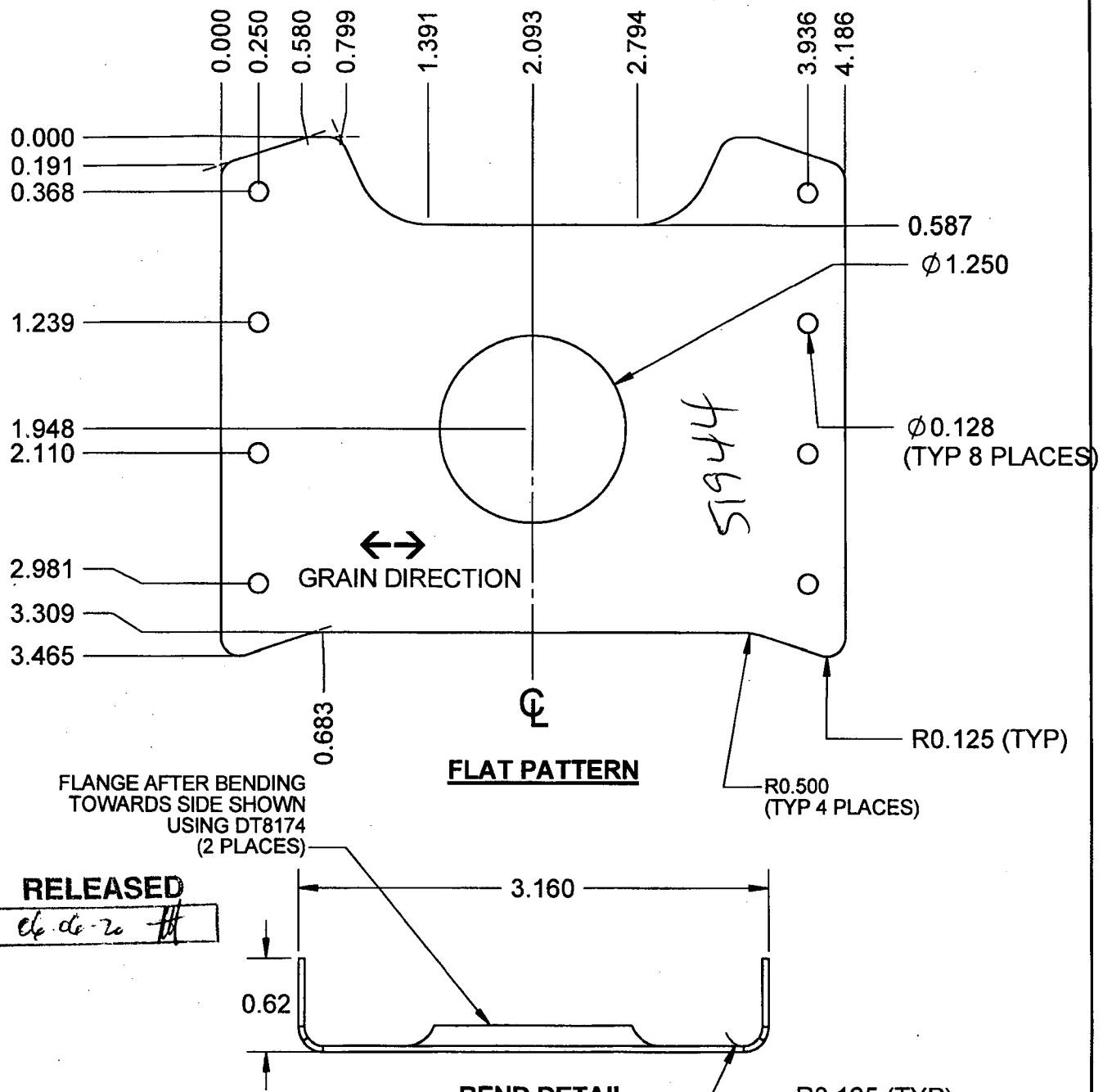
**RELEASED**06.06.20 *[Signature]***D3065-041 STEP LEG ASSEMBLY**

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| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>M</i>  | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 2 OF 5 |
| DATE<br>06.05.23     |                       | TITLE<br>STEP LEG ASSEMBLY                        | SCALE<br>1:1           |



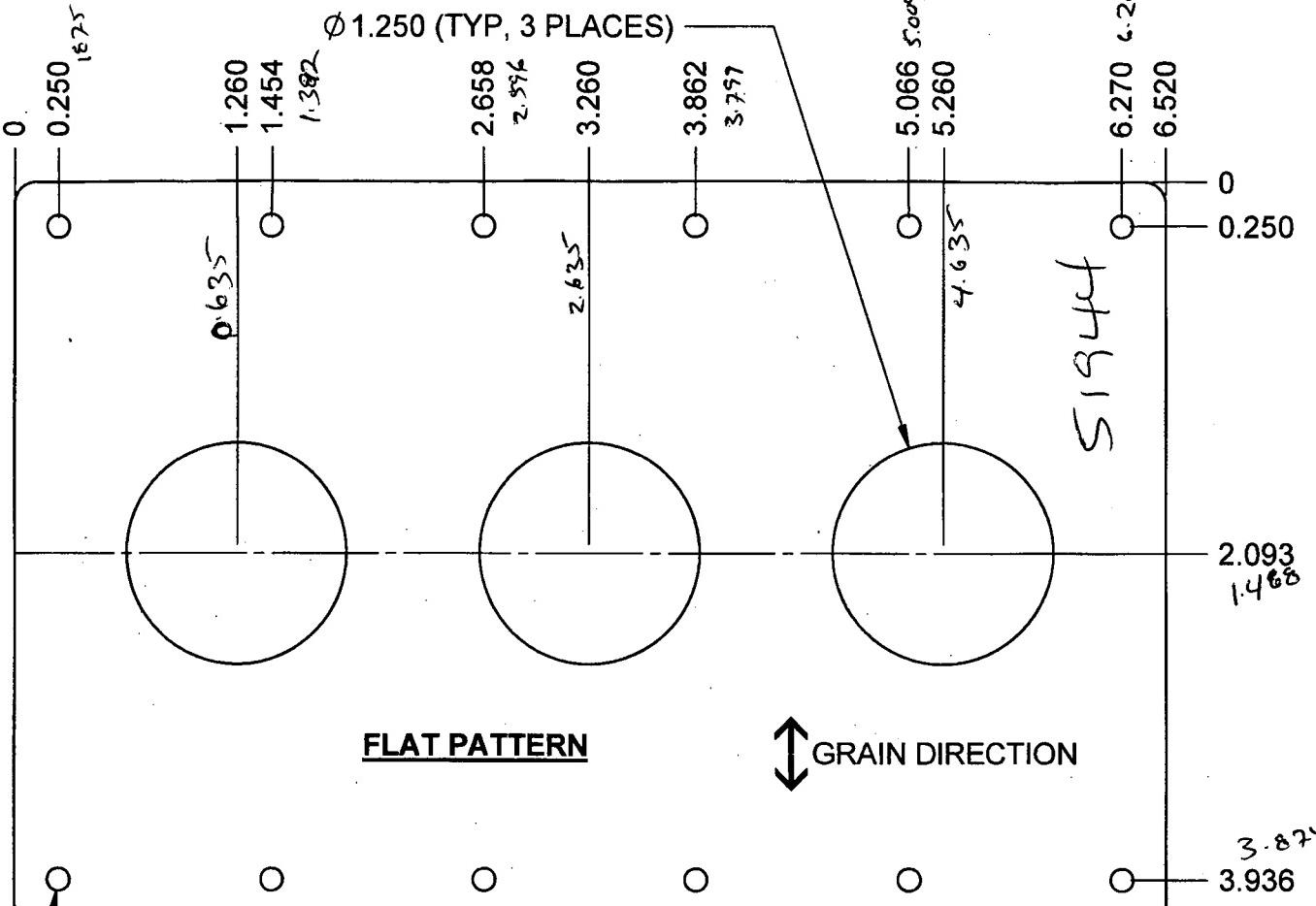
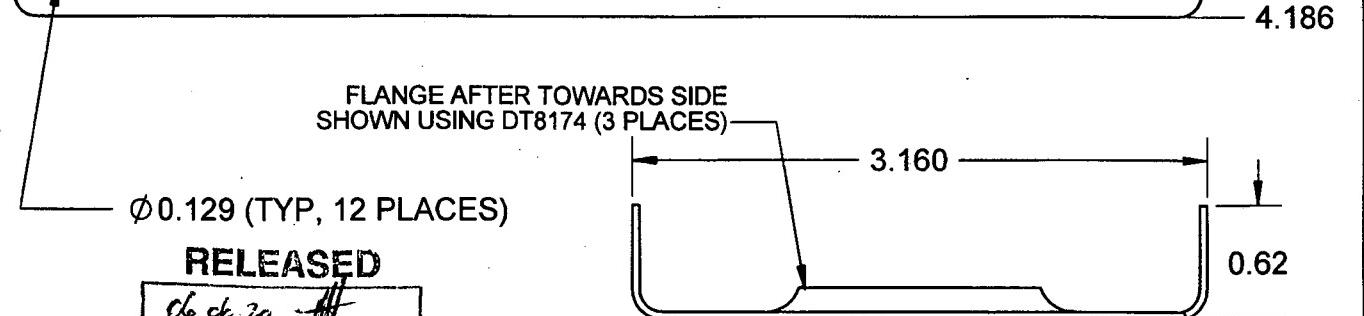
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>      | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>MM</i>      | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 3 OF 5 |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | SCALE<br>1:1                                      |                        |

**FLAT PATTERN****GRAIN DIRECTION****BEND DETAIL****D3065-3 STEP SPACER**

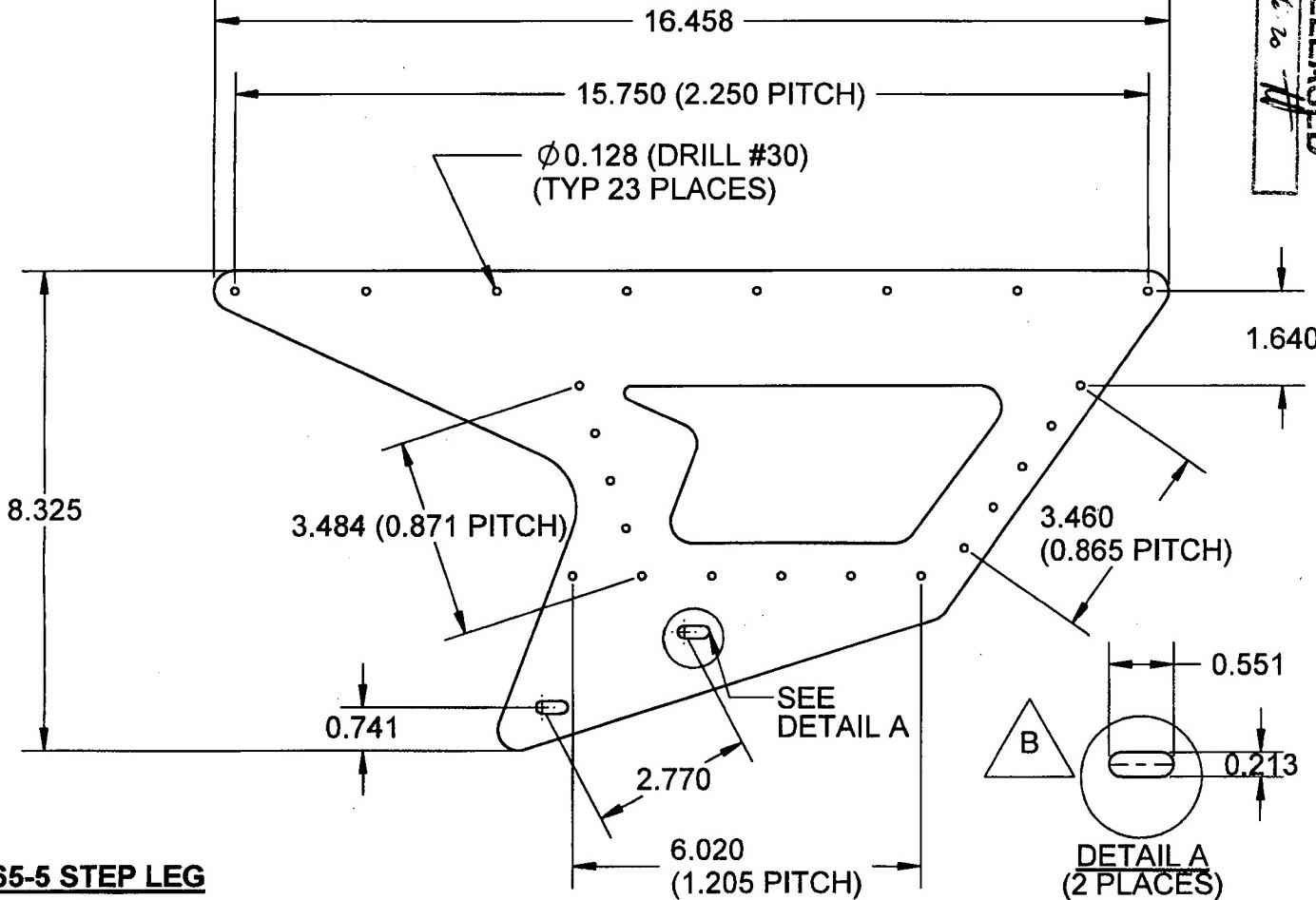
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

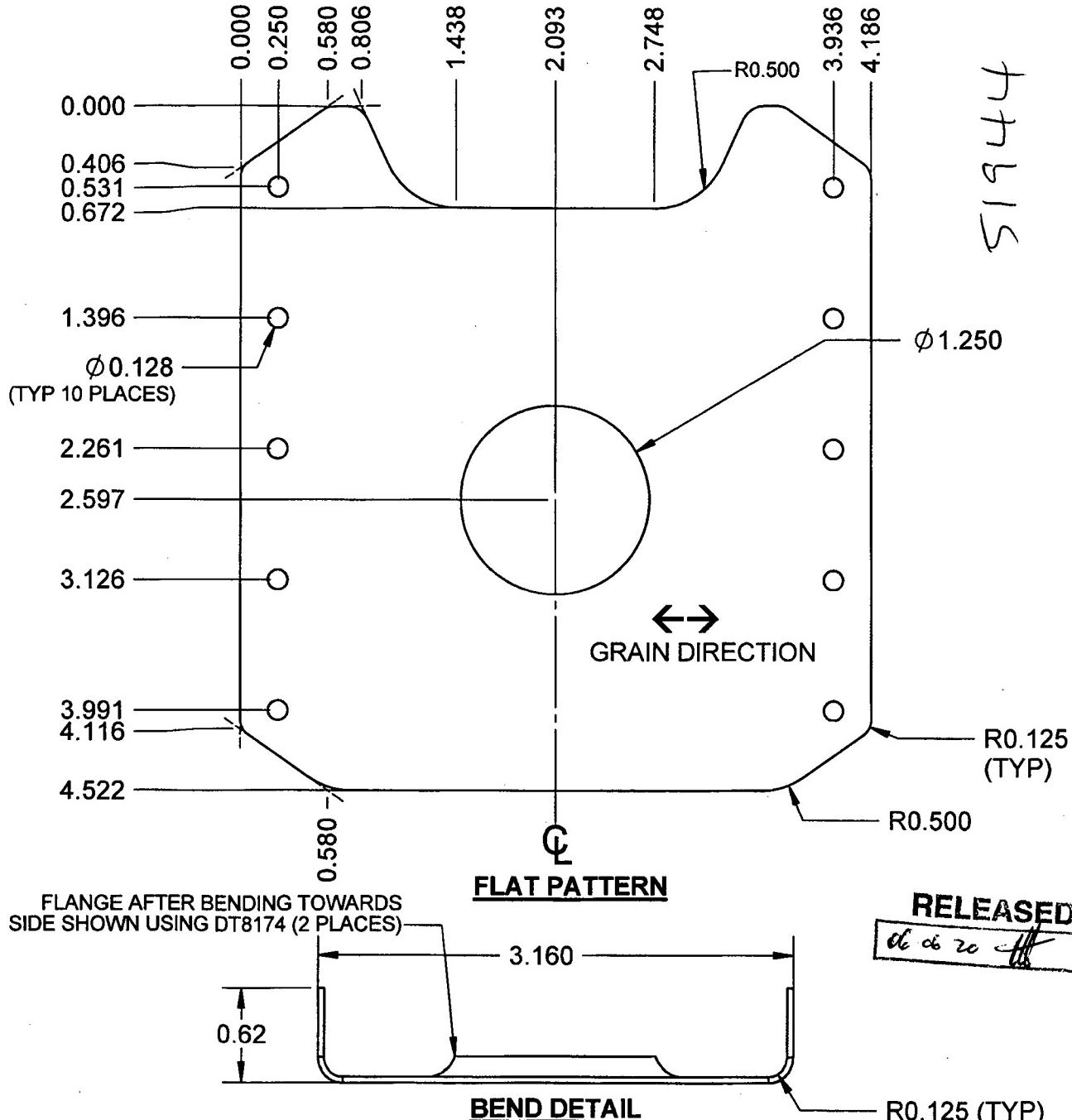
|         |          |  |
|---------|----------|--|
| DESIGN  | DRAWN BY | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO.<br><b>D3065</b>                              |
| DATE    | 06.05.23 | TITLE<br><b>STEP LEG ASSEMBLY</b>                        |

**RELEASED**  
06.06.20 *H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
  - 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
  - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 6) ALL DIMENSIONS ARE IN INCHES
- 51944

**DART**

|                      |                            |   |                        |
|----------------------|----------------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>      | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>CH</i>      | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 5 OF 5 |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | SCALE<br>1:1                                      | <i>51944</i>           |

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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